

**Work Order ID 62540**

Monday, October 04, 2010 10:55:01 AM



Page 1

Item ID: D119-646-452

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplates, RH, OEM

Start Date: 10/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI 9526

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file &amp; type labels as per PPP D119-646-452 / DSI 9526 CHG 001

810101014

H. J. BB 10-10-12

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/10/12sf

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

810101014

GC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62540**

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Item ID: D119-646-452

Accept

Setup Start

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Item Name: Wearplates, RH, OEM

Start Date: 10/4/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/20/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D119-646-452 / DSI 9526

Location: \_\_\_\_\_

PPP rev: A

10/10/14

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/10/18

10-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Monday, October 04, 2010 10:55:05 AM

Work Order ID: 62540

Parent Item: D119-646-452

Parent Item Name: Wearplates, RH, OEM






Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.25 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4132-042  Wearplate, RH Fwd		Manufactured	No			110	Each	2.0000	1	10/10/12SP			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				2					
					62346			2					
D4133-041  Wearplate, Mid		Manufactured	No			110	Each	2.0000	1	10/10/12SP			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				2					
					62155			2					
D4134-042  Wearplate, RH Aft		Manufactured	No			110	Each	1.0000	1	10/10/12SP			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST				1					
					62158			1					
D4135-1  Wearpad		Manufactured	No			110	Each	2.0000	3	10/10/14SP			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2					
					60167			2					
ALS7-1032-130  INSERT		Purchased	No			110	Each	0.0000	20	11/15/079 10/10/12SP			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
								20					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Monday, October 04, 2010 10:55:05 AM

Work Order ID: 62540

Parent Item: D119-646-452

Parent Item Name: Wearplates, RH, OEM

Start Date: 10/4/2010

Required Date: 10/20/2010

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-225

AELS-1032-225

Purchased

No

110

Each

0.0000

12

12

INSERT

AN3C5A

Purchased

No

110

Each

842.0000

54

54

Bolt

Location

Loc Qty

Loc Code

ST350

832

114330

11

115015

16

115316

105

115371

100

115422

100

115594

500

ST351

10

113121

10

NAS1149C0332R

Purchased

No

110

Each

1,799.000

54

54

Washer

Location

Loc Qty

Loc Code

ST297

1799

113524

10

113737

150

115000

125

115698

114

115816

1400

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# REFERENCE

## PARTS LIST

QTY -451	QTY -452	PART NUMBER	DESCRIPTION
X		D119-646-451	WEARPLATE KIT, OEM LH
	X	D119-646-452	WEARPLATE KIT, OEM RH
1		D4132-041	WEARPLATE, FWD LH
1		*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4132-042	WEARPLATE, FWD RH
	1	*D4132-3	GASKET (BONDED WITH 3M 1300/1300L)
1	1	D4133-041	WEARPLATE, MID
1	1	*D4133-3	GASKET (BONDED WITH 3M 1300/1300L)
1		D4134-041	WEARPLATE, AFT
1		*D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
	1	D4134-042	WEARPLATE, AFT
	1	D4134-3	GASKET (BONDED WITH 3M 1300/1300L)
3	3	D4135-1	WEARPAD
20	20	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
54	54	AN3C5A	BOLT
54	54	NAS1149CO332R	WASHER

\* denotes that part is included in assembly above

## WEIGHT AND BALANCE

The following weight and balance information is for the Dart D119-646-451/-452 kits only. The weight and balance of the wearplates removed are the responsibility of the installer.

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D119-646-451	10.8 lb	117.7 in	1271 in lb	-39.4 in	-426 in lb
WEARPLATE KIT, LH	4.9 kg	2.99 m	14.7 m kg	-1.00 m	-4.9 m kg
D119-646-452	10.8 lb	117.7 in	1271 in lb	+39.4 in	+426 in lb
WEARPLATE KIT, RH	4.9 kg	2.99 m	14.7 m kg	+1.00 m	+4.9 m kg

DESIGN	qp	<b>DART AEROSPACE USA, INC</b>	
DRAWN	qp	PORT HADLOCK, WA	
CHECKED	HA	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9526	SHEET 2 OF 3
APPROVED	HA	TITLE	SCALE
DE APPR.	HA	OEM WEARPLATE KIT	NTS
DATE	10.06.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	